

Date: Tuesday, 11/29/2005 7:14:45 PM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STOP
Job Number	: 25048A		
Estimate Number	: 10731		
P.O. Number	: N/A	Part Number	: D23243
This Issue	: 11/29/2005	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D2324 REV. C
First Issue	: N/A	Project Number	: N/A
Previous Run	: 24528A	Drawing Revision	: C
		Material	: N/A
		Due Date	: 12/6/2005
Written By	: <u>See comment below</u>	Qty:	20 Um: Each
Checked & Approved By	: <u>See comment below</u>		
Comment	: Est: E 03.02.28 Reformat; Incorporated D2324-3 & D2324-5K J/RF		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
---------	-----------------------	--------------

1.0	M6061T6B0750X00750	6061-T6 Bar .75" x .75"
-----	--------------------	-------------------------



Comment: Qty.: 0.5565 f(s)/Unit Total: 11.1300 f(s)

6061-T6 Bar 0.75" x 0.75"

Material: 6061-T6/6511 (QQ-A-200/8) or (QQ-A-225/8) or 5052-H34 (QQ-A-225/7) or (QQ-A-250/8)

(M6061T6B0.750x00.750)

Batch: ~~M19838~~ M18398

2.0	BAND SAW	BAND SAW
-----	----------	----------



Comment: BAND SAW

Cut blanks: (0.75" x 0.75") x 5.75" Long Bar

J-L 05.12.11 20

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #1

1- Machine as per Folio D2324-3 and Dwg D2324

2- Deburr and Tumble to remove sharp edges

Identify as D2324-3

J-L 05.12.12 20

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J-L 05.12.12 20

5.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

CP 05.12.12 20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 05/12/12
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
05-12-12	3	1 part cut too short did not machine completely	 05-12-12	scrap and replace	J.L. 05-12-12	 05-12-12	 05-12-12	 05-12-12

NOTE: Date & initial all entries

Date: Tuesday, 11/29/2005 7:14:46 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STOP

Job Number: 25048A

Part Number: D23243

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

FF 05/12/15

20

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT ALODINE

SB 05/12/15

20

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

SB 05/12/15

20

9.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SAC 05/12/16 (20)

SB 05/12/16

(20)

Job Completion





W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

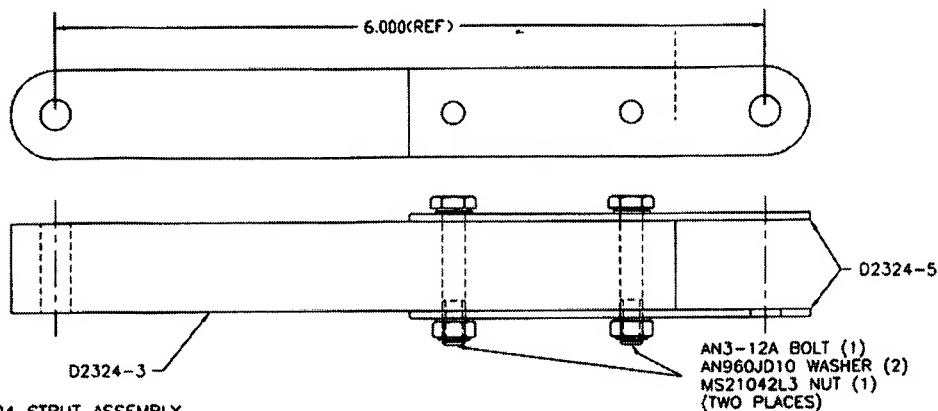

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

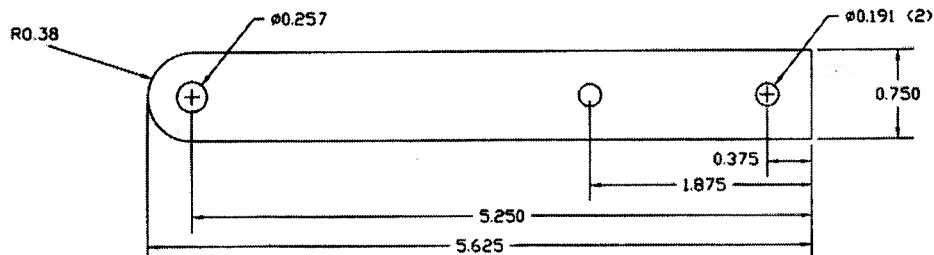
NOTE: Date & initial all entries

DART

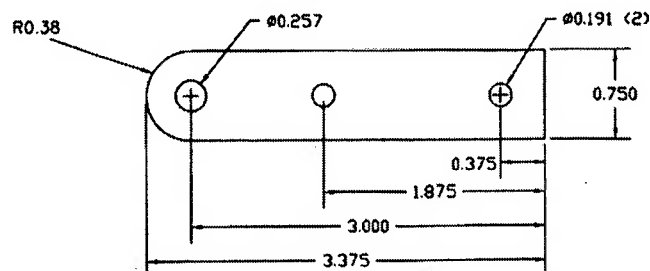
DESIGN	DRAWN BY	DART AEROSPACE LTD	
B WILLIAMS	PH	VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED 	APPROVED 	DRAWING NO.	REV. C
		D2324	SHEET 1 OF 1
DATE		TITLE	SCALE
04.12.14		STRUT	
A	94.11.08	NEW ISSUE	
B	96.05.07	UPDATE MATERIALS	
C	04.12.14	UPDATE NOTES	

RELEASED04.12.16 **D2324 STRUT ASSEMBLY**

- 1) IDENTIFY WITH DART P/N D2324 USING FINE POINT PERMANENT INK MARKER

**D2324-3**

- 1) MATERIAL: 6061-T6/T651 BAR (Q0-A-200/8) 0.75 X 0.75
(REF DART SPEC. M6061T6B0.750X0.750)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

**D2324-5**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET 16 GAUGE (0.063 THICK)
(REF DART SPEC. M304S16GA)
- 2) FINISH: POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED